

Work Order ID 79624

79624

Page 1

January-30-12 2:41:47 PM

Item ID: D3806-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: " Stop ***NS2***
 Item Name: Bar
 Start Date: 30/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 13/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00
100
 Cold Saw Memo 0.00 OK 12/02/14 10 10
 Hyd Mech Cut blanks at 44.50"
 ***FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON
 LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING***

110 0.00
110
 HAAS 1 Memo 0.00 OK 12/02/14 10 10
 HAAS CNC vertical machine #1 1-Mill as per folio FB070 & dwg
 FOLIO REV: 44
 DWG REV: 3
 2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control	***FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING***								
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
133	Weld per dwg A/R Hardcoat S.S. Batch: _____	0.00							
133									
Large Fab	Memo	0.00							
Large Fab	1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3806 2059 B Hardcoat Welding Rod BATCH#: _____								
	CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT								

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

79624

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N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Run Start *NR1*

Tooling:

Date:

Stop *NR2*

SPC (Y/N):

Date:

Insp.
Stamp

0.00

Memo

0.00

0.00

Memo

0.00

0.00

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Work Order ID 79624***79624***

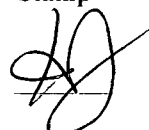
Page 4

January-30-12 2:41:47 PM

Item ID: D3806-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 30/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 13/02/2012 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/2/21 P12-02-17
(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-30-12 2:41:50 PM

Page 1

Work Order ID: 79624

79624

Parent Item: D3806-5

D3806-5

Parent Item Name: Bar

Start Date: 30/01/2012

Required Date: 13/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
IPP Rev:B 08-09-23 redesign DD verified by:EC
IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No				f	0.0000		38.58947			

M304B0 250x0 500

304 BAR .250 x .500

**

1120488X

41.4 on 12/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79624
Description: Bar		Part Number:	D3806-5
Inspection Dwg: D3806	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.00			M-type 1204	
7.00	+/-0.030	7.00				
4.00	+/-0.030	4.00				
14.00	+/-0.030	14.00				
31.00	+/-0.030	31.00				
38.00	+/-0.030	38.00				
43.50	+/-0.030	43.50				
0.500	+/-0.010	.490				
0.200	+/-0.010					
0.080	+/-0.010					
.130		.130			DIN 11206	

Measured by: <i>anf</i>	Audited by: <i>ll</i>	Prototype Approval:	N/A
Date: 12/02/14	Date: 12-02-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

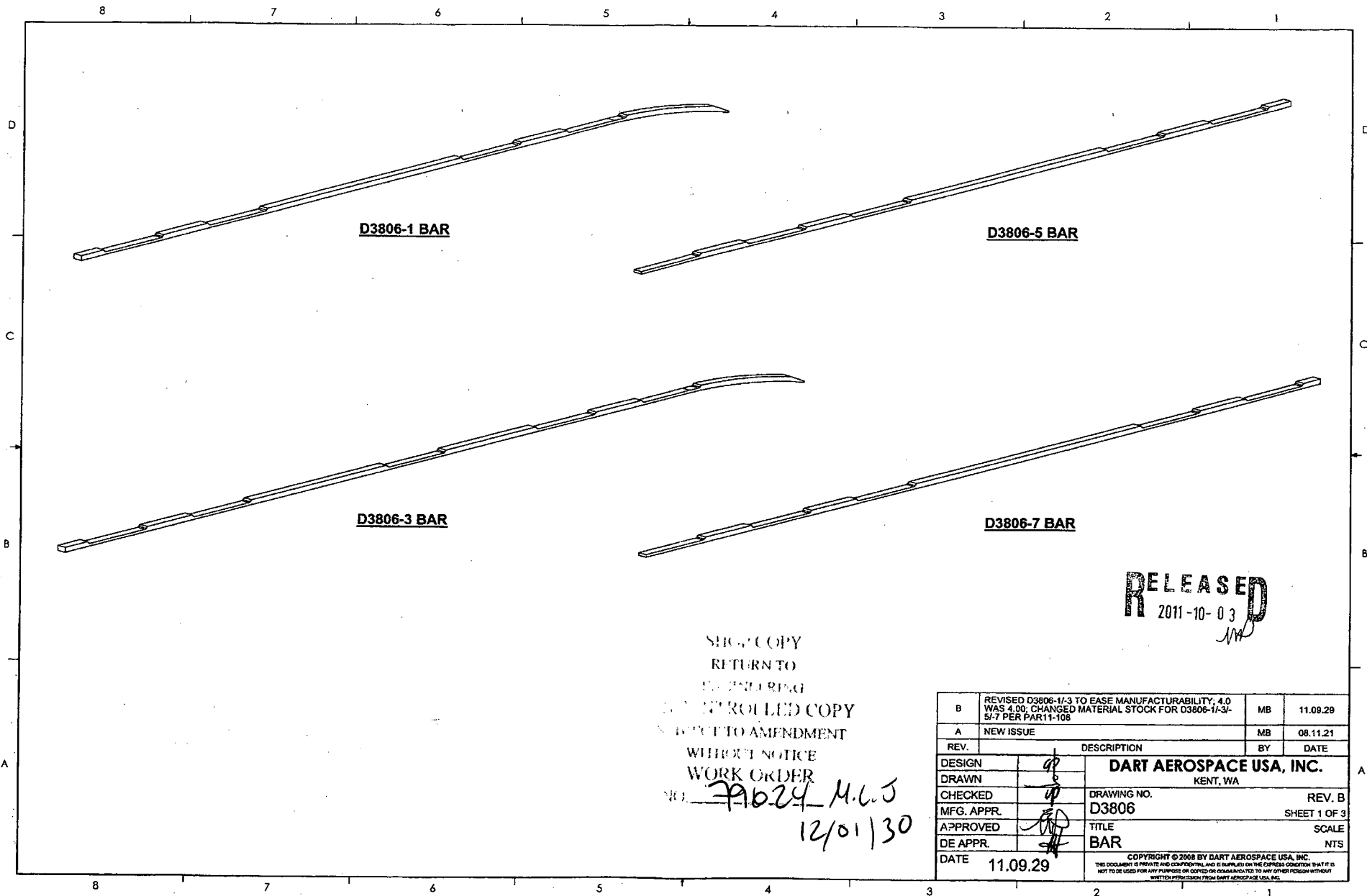
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NOTE: Date & initial all entries



RELEASED
2011-10-03

SHG COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 79624 M.L.J
12/01/30

B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PAR11-108		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3806		REV. B	
MFG. APPR.	TITLE BAR		SHEET 1 OF 3	
APPROVED	DATE 11.09.29		SCALE NTS	
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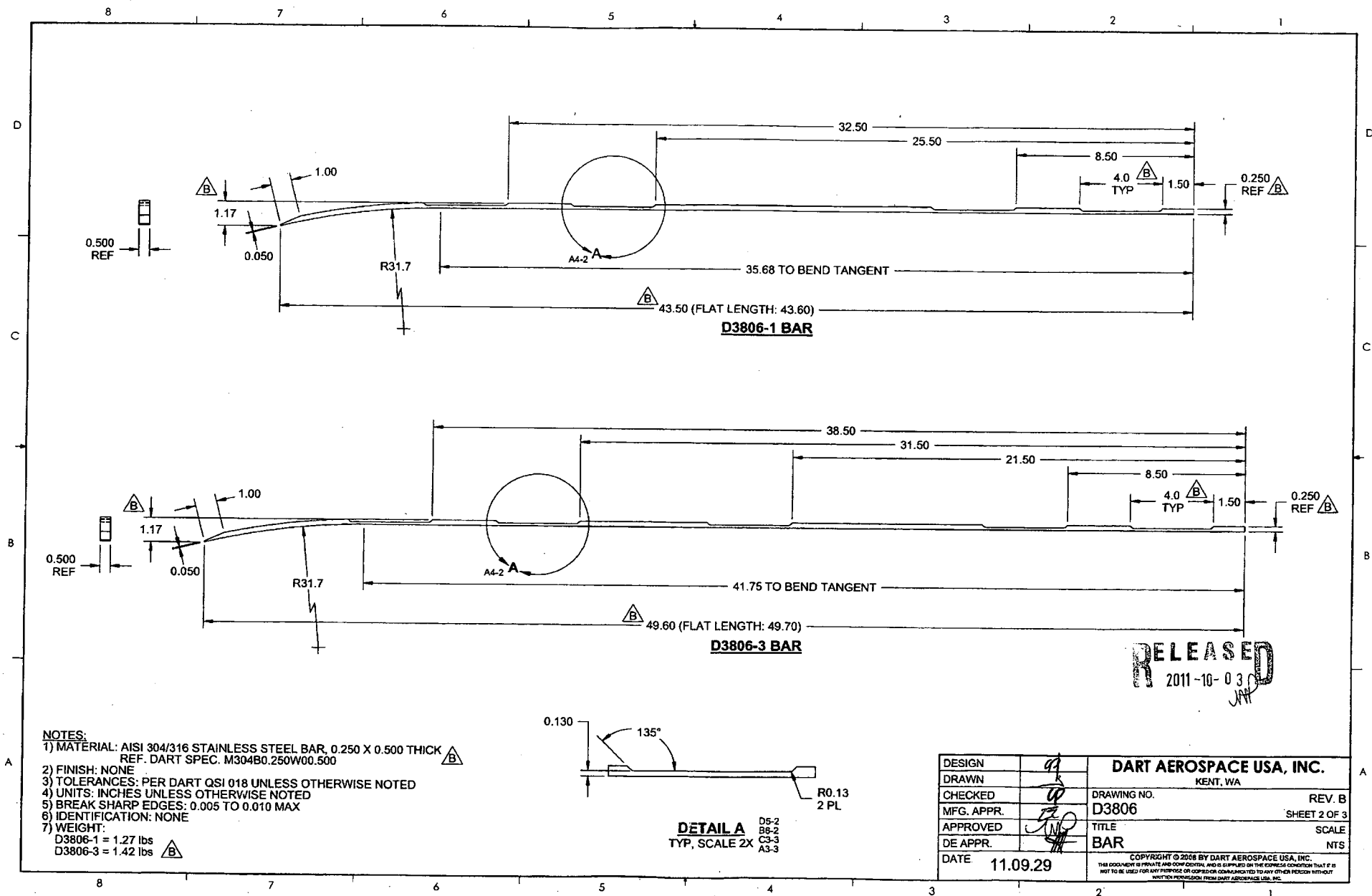
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

79624



RELEASED
2011-10-03

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN	91	
CHECKED	UP	
MFG. APPR.		
APPROVED	[Signature]	
DE APPR.	[Signature]	
DATE	11.09.29	
		DRAWING NO. D3806 REV. B SHEET 2 OF 3 TITLE BAR SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>

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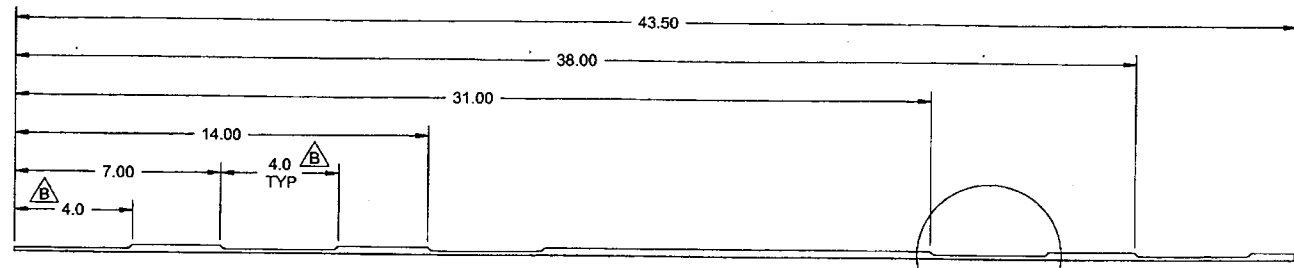
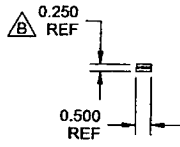
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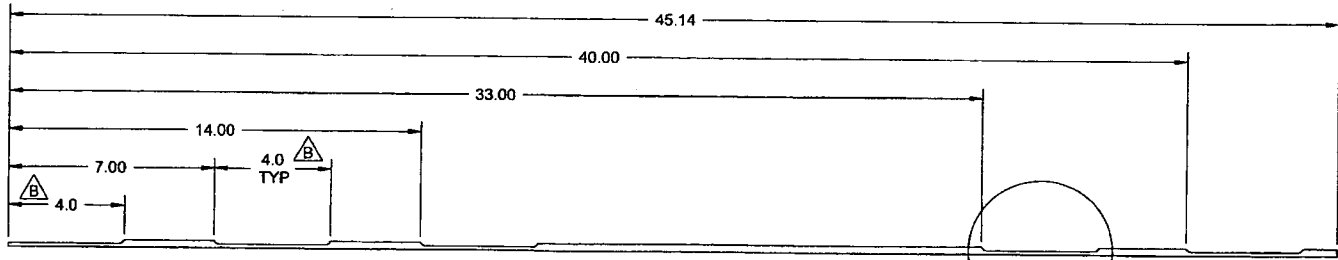
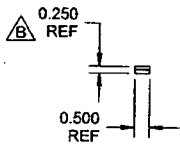
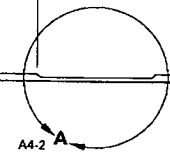
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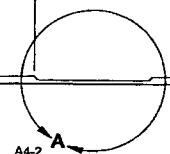
79624



D3806-5 BAR



D3806-7 BAR



RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3806	REV. B
MFG. APPR.		TITLE BAR	SHEET 3 OF 3
APPROVED		DATE 11.09.29	SCALE NTS
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